Work Order II Tuesday, October 04, .										,	Page 1
Item ID: D353 Revision ID: Item Name: Wears		Α	ccept					Setup	Start Stop		
Start Date: 9/30/2 Required Date: 10/14 Reference:	2011 Start Qty: 10.00			Cust Item I Customer:	<b>D:</b>				-		14 14 14 14 14 14 14 14 14 14 14 14 14 1
	cess Plan: M C. J	Date: \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	Tooling: SPC (Y/N):		nte:			Run	Start Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	,			. 57		,	1			
D3535  100  Waterjet  FLOW CNC Waterjet  354,046	Rev B  FLOW WATER JET  Memo 1-Cut as po	er Dwg D3535 □Dwg Rev:_ eccessary	0.00  0.00  Prog Rev:	□2-			<u>B</u> 11-	10	27	(L	 
110 QC Quality Control	QC2- Inspect parts off i	machine FAI/FAIB	0.00				- B/L	- 10 - '	<b>7</b> 7		
120 QC Quality Control	QC8- Inspect parts - se	cond check	0.00 Sul	10178	,		(e14	<b>)</b> —			

Dart Aerospac	e:	Ltd
---------------	----	-----

Dart Ae	rospace I	Ltd						<b>6</b> 3
W/O:			WC	RK ORDER CHANGES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·					
Part No	:	PAR #:	Fault Cate	gory: N	CR: Yes	No <b>DQA</b> :	Date: _	
	Res	solution:	Dispositio	n: Q	A: N/C Clo	sed:	Date: _	
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK ORD	ER NON-CONFORMANC	E (NCR	)		
DATE	CTED	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
							:	

11011.					` '			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
								and the second
•								
		,						
		and the second second						
	· ·	1	1		į	l	1	

#### Work Order ID 74525

Tuesday, October 04, 2011 8:17:33 AM



Page 2

Item ID:

D3535-25

Accept

Setup Start

Stop

Stop



**Revision ID:** 

**Item Name:** Wearshoe

9/30/2011

Start Qty: 10.00

Req'd Qty: 10.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Start Date:** 

**Approvals:** 

**Process Plan:** 

Date:

Date:

Tooling: SPC (Y/N):

Date:

Date:

Run Start



Sequence ID/

**Required Date: 10/14/2011** 

Operation Description

NC BRAKE

Set Up/ **Run Hours**  Toel-ID

Tool # Plan Code Accept Qty

15,32-

Reject Oty

Reject Insp. Number Stamp

**Work Center ID** 130

Brake NC

Brake NC

Memo

0.00

0.00

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326  $\square$  2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25

140



Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

□FINISH TIME:

8 m/ 11/11/01

W/O:			W	ORK ORDER CHANGE	ES	•			
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	!								
								12	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
	R	esolution:	Dispositio	n:	QA: N/C C	osed:		Date: _	
NCR:	,		WORK ORD	ER NON-CONFORMA	NCE (NCF	?)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	eation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	k   Secti		Chief Eng	QC Inspector
					:				
								-	

#### Work Order ID 74525

Tuesday, October 04, 2011 8:17:33 AM



Page 3

Item ID:

D3535-25

Accept



Setup Start



**Revision ID:** 

Item Name:

Wearshoe

**Start Date:** 

**Required Date: 10/14/2011** 

9/30/2011

**Start Oty: 10.00** Req'd Qty: 10.00



**Cust Item ID: Customer:** 

Tool ID

Reference:

**Approvals:** 

Process Plan: QC:

Date:

Date: \_\_\_\_\_

**Tooling:** 

SPC (Y/N):

Date:

Date:

Tool#

Plan

Code

Run

Start

Stop

Stop



Sequence ID/

**Work Center ID** 

160

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

Accept

Otv

Reject Oty

Reject Insp. Stamp Number

14 Bl 11-11-2

170

Packaging

Packaging

Identify as per dwg & Stock Location

0.00

0.00

14 Bl 11-11-2

180

QC

Quality Control

OC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

W/O:	· · · · · · · · · · · · · · · · · · ·		W	ORK ORDER CHAI	VGES				
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	NCF	l: Yes N	lo DQA:	Date: _	
		esolution:							
NCR:		V	VORK OR	DER NON-CONFOR	MANCE	(NCR)			
DATE	STEP	Description of NC			Section B	Ciam 0	Verification		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date	Section C	Chief Eng	QC Inspector

#### **Picklist Print**

Tuesday, October 04, 2011 8:17:40 AM

Work Order ID: 74525

D3535-25 Parent Item:

Parent Item Name:

Wearshoe



Start Date: 9/30/2011

**Required Date: 10/14/2011** 

Page 1

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM

Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	170.5795	0.51	5.368421 RIF	7.		

304/316 .040 Sheet

Location	Loc Qty	Loc Code	
MAT020	17.0.5795		
116623	0.2	•	
117550	8.363		(\\
117933	45.3442		\ \'
118400	33.6723		
118964	83		119346
119341			,

Dart Aerospace Ltd	Dart	Aero	ospa	ce Ltd
--------------------	------	------	------	--------

	•								
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Resc	olution:	Disposition		_ QA: N/C C	losed:	-	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	₹)			· · · · · · · · · · · · · · · · · · ·
DATE STED		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign and Date	Secti	on C	Chief Eng	QC Inspector
<del></del>									

They wanted to

DART AEROSPACE LTD	Work Order:	74525
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

a de Martin

#### FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing	Tolerance	Actual Accept Rej		Reject	Method of	Comments
Dimension	Tololulloo	Dimension			Inspection	
1.885	+/-0.010	1.888	<b>&gt;</b>		V 1362	
1.937	+/-0.010	1. 934	2		V	
1.450	+/-0.010	1.450	¥		V	
5.450	+/-0.010	5,450	₹	r	7 B01	ž . 50
10.900	+/-0.010	10.906	D		7	
16.350	+/-0.010	16.350	₽		7	
21.800	+/-0.010	21.800	Q		7	
Ø0.188	+0.005/-0.001	.192	0		V	
12.750	+/-0.010	12.750	P		7	
6.75	+/-0.030	6.75	7		7	
6.00	+/-0.030	6.00	コ		T	
0.300	+/-0.010	. 305	0		$\dot{\nu}$	
0.300	+/-0.010	- 303	8		U	
0.038	+/-0.010	.35	\		V	
			-			

Measured by: \B	Audited by:	Prototype Approval:	N/A
Date: 11-10-27	Date: 11/10/28	Date:	N/A

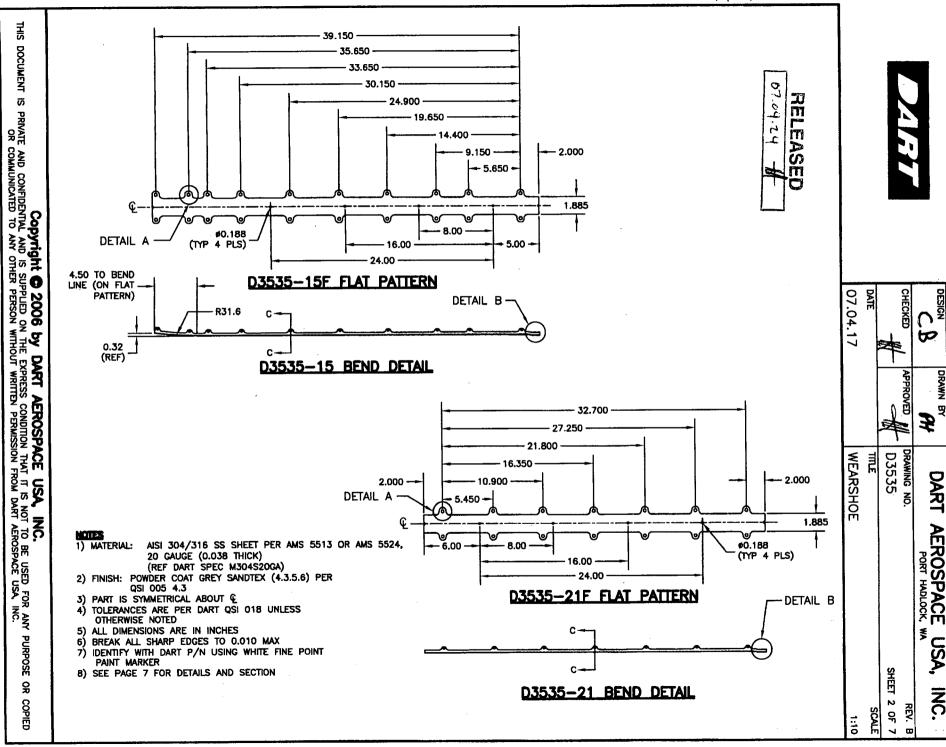
Rev	Date	Change	Revised by	Approved
Α	07.11.23	New Issue	KJ/EC/DD , X()	
L				<b>V</b>

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector			
Part No		PAR #:	Fault Categ	jory:	NCR: Ye	s No	DQA:	Date: _				
	R	esolution:	Disposition	:	QA: N/C	Closed:	**********	Date: _				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NO	CR)						
DATE	STEP	Description of NC		ection B	Ve	Verification	Approval	Approval				
		Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da		Section C	Chief Eng	QC Inspector			
1 :												
		**************************************										

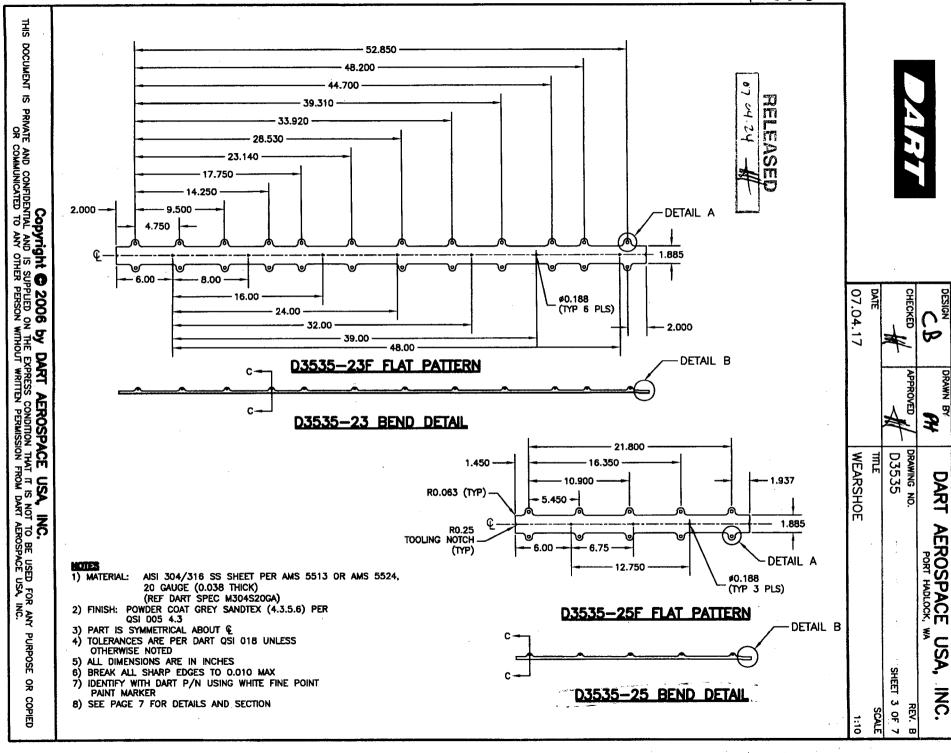
<sup>•</sup> H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

145 10

W/O:			W	ORK ORDER CHANG	SES	***************************************	· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				, na varva				1 Too Migi	
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQA:		_ Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C Cld	osed:	•	_ Date: _	
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCR	)			
DATE	STEP	Description of NC	Corrective Action		tion B	Verification	Verification	Approval Appro	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
					:				
						•			
			1		1	ŀ	1		1



W/O:	·		WO	RK ORDER CHANG	GES				
DATE STEP		PRO	OCEDURE CHAN		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:							
	Re	solution:	Disposition	•	QA: N/C (	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action		ction B	Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	tion C	Chief Eng	QC Inspector
									!
į l		·							



W/O:			W	ORK ORDER CHANGI	ES					
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,						1 Tod Wgi	
Part No	•	PAR #:	Fault Cate	gory:	NCR	: Yes N	lo DQA:		_ Date: _	
	R	esolution:	Disposition	n:	_ QA:	N/C Clo	sed:		Date:	
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC		**************************************	Verification   Approval			Approval		
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C		Chief Eng	QC Inspector	
									:	
:										
					-					
				·						

h2.40.60

RELEASED

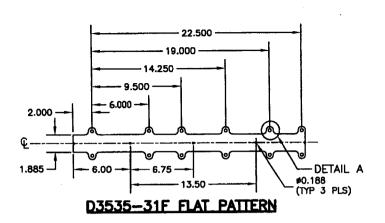
RC.

4 OF 7 RP EV

SCALE 1:10

07.04.17

WEARSHOE





D3535-31 BEND DETAIL

D3535-33 BEND DETAIL

ũ	EB	
١.	MATERIAL	

봀

DOCUMENT

ភ

PRIVATE

Copyright © 2006 by DART AEROSPACE USA, IN AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART .

INC.
OT TO BE USED FOR ANY
OT AEROSPACE USA, INC.

PURPOSE

유

COPIED

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT Q.
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

	•								
W/O:			WO	RK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
· · · · · · · · · · · · · · · · · · ·									
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Ye	s No	DQA:	Date: _	
	Re	esolution:	Disposition	Disposition: QA				Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC			tion B	Ve	rification	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n &	Section C	Chief Eng	QC Inspector
		·							
	1 1		1		1	1		1	1

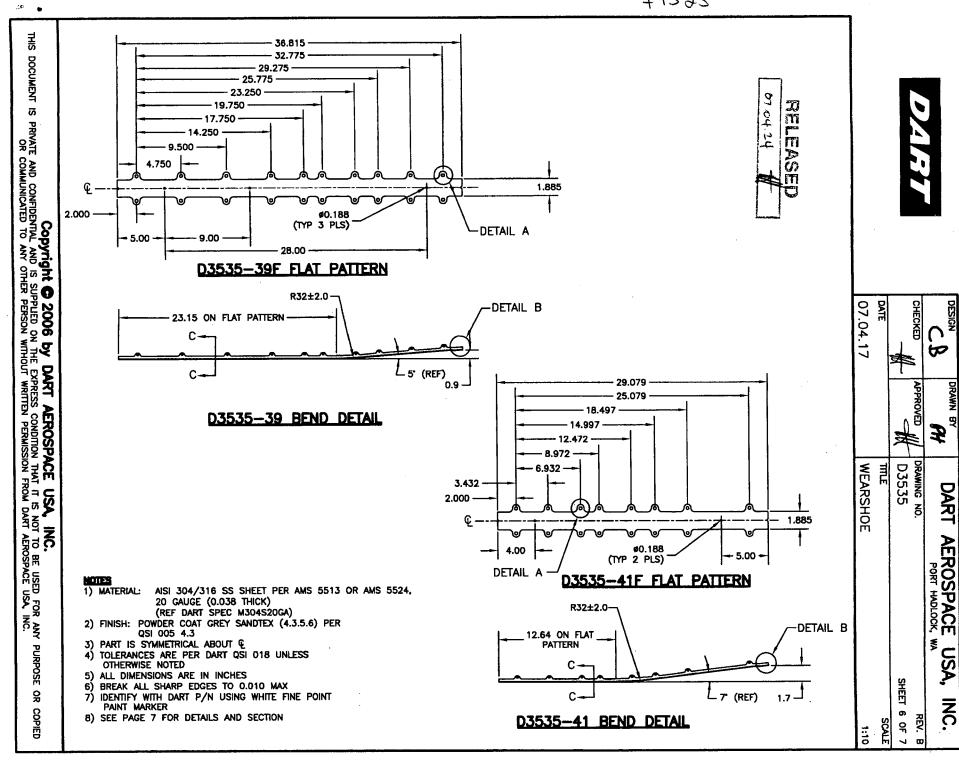
뒾S DOCUMENT 23.250 19.750 42.40.60 RELEASE ß 17,750 Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 14.250 9.500 4.750 2.000 #0.188 1.885 (TYP 2 PLS) DETAIL A D3535-35F\_FLAT\_PATTERN DATE CHECKED 07.04.17 D3535-35 BEND DETAIL B 27.250 22.500 3 17.750 14.250 DRAWING NO. WEARSHOE DART 4.750 2.000 AEROSPACE PORT HADLOCK. 6.00 1.885 DETAIL A 21.00 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCLINE #0.188 (TYP 4 PLS) D3535-37F FLAT PATTERN PURPOSE 5) ALL DIMENSIONS ARE IN INCHES SHEET 6) BREAK ALL SHARP EDGES TO 0.010 MAX 욹 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT ZC. D3535-37 BEND DETAIL COPIED 5 OF 7 PAINT MARKER SCALE 8) SEE PAGE 7 FOR DETAILS AND SECTION 1:10

Dart Aerospace L	_td
------------------	-----

W/O:			WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE			Ву	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
										<u>.                                    </u>		
Part No:		PAR #:	Fault Category:			es N	o DQA	<b>\</b> :	Date:			
	Re	esolution:	on: Disposition:			QA: N/C Closed:				Date:		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	CR)	78.5					
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description			B Sign &		ation	Approval	Approval		
		Section A	Chief Eng	Chief Eng		ate	Section	on C	Chief Eng	QC Inspector		
							· · · · · · · · · · · · · · · · · · ·					
	}				-							

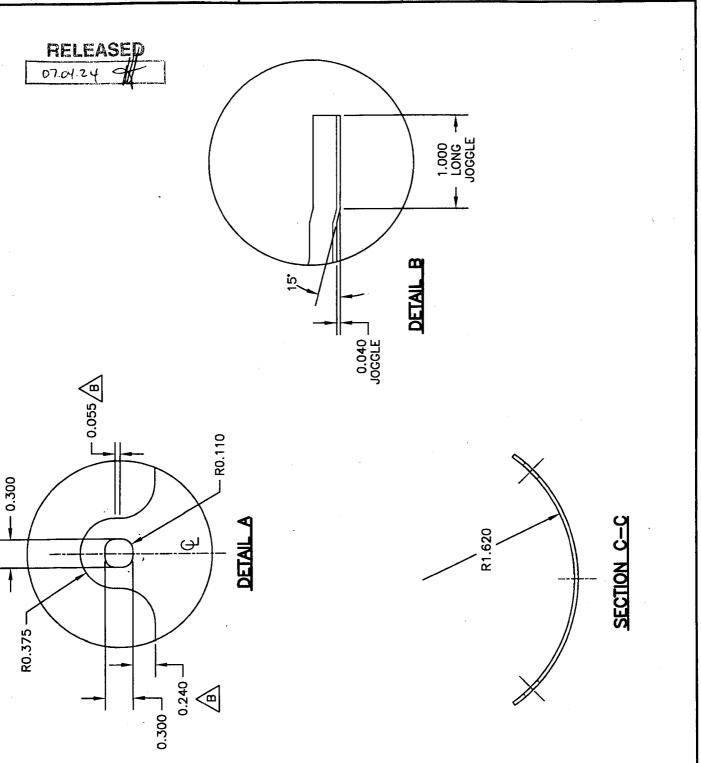


D	art	Aeı	ros	pace	Ltd
---	-----	-----	-----	------	-----

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date: _			
	Re	esolution:	Disposition	າ:	QA: N/C (	Closed:		Date:			
NCR:		\	WORK ORDI	R NON-CONFORM	ANCE (NC	R)					
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descr Chief Eng Chief Eng		Section B otion Sign & Date		cation ion C	Approval Chief Eng	Approval QC inspector		
				Only Ling							
i											
	1		1		ĺ						



DESIGN DRAWN BY DART AEROSPACE USA, INC. PH DRAWING NO. REV. B CHECKED APPROVED D3535 SHEET 7 OF 7 SCALE TITLE DATE **WEARSHOE** 07.04.17 1:1



Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Dart Ae	rospace Lt	rd .		• /						y & .
W/O:			WC	ORK ORDER CHA	NGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto	
			<u> </u>							
						,		·		
							election of the second of the			
Part No:		PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	A:	Date: _	J
		olution:								
NCR:				ER NON-CONFOR						
DATE	STEP	Description of NC Section A		Section B	A.W.C.	Vorifi	cation	Approval	Approval	
DATE			Initial Chief Eng	Action Description Chief Eng	on	Sign Date	& Sect	ion C	Chief Eng	Approval QC Inspector
			,							